

Wednesday, August 24, 2011 2:25:05 PM

[illegible][illegible]

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the effectiveness of the plan and identifying any areas for improvement or further action.

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Customer:

[illegible]

Reference:

Date: 1-08-24

Date:

Abstract

Date:

Date:

Stop



Draw Nbr	Revision Nbr	
D2332	Rev C1	

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00



Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to lenght as per dwg D2332 using DT8012
(need 2 per ass'y)

25/08/29 (10)

ES 11/08/29 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73039

Wednesday, August 24, 2011 2:25:05 PM



Page 2

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Item Name: Lid Prop Assembly 6.69" long

Stop



Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

Signature 8/29/08 (10)

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

D2332-7 - S u l o e l r e (10)
D2332-5 - S u l o e l r e (10)
D2332-11 - S u l o e l r e (10)
D2332-13 - S u l o e l r e (10)

Signature u l o e l r e (10)

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M114649

11.08.31 *Signature* / PMB 11/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73039

Wednesday, August 24, 2011 2:25:05 PM



Page 4

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location 512 0.00

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8469107

SP

12

SP

11-09-08

11/9/8

ME
11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 24, 2011 2:25:10 PM

Page 1

Work Order ID: 73039

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 8/24/2011

Required Date: 8/31/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250 		Purchased	No			100	f	10.0427	0.1	1.052632		8/24/08/29	
304 SS Round bar .250													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT028		10.042736				1.052632			
				114482		10.042736							
M304TR1.000W.049 		Purchased	No			100	f	28.1337	0.43	4.526316		8/24/08/29	
304 RD Tube 1.00 x .049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		28.133684				4.526316			
				111457		12.66							
				117598		15.473684							
M304TR0.500W.035 		Purchased	No			110	f	62.3165	1.25	13.15789		8/24/08/29	
304 RD Tube .500 x .035W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT017		62.316478				13.15789			
				115535		2.33							
				116720		1.66068							
				117598		58.325798							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 24, 2011 2:25:11 PM

Work Order ID: 73039

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 8/24/2011

Required Date: 8/31/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No 170 Each 70.0000 1 10
Bolt



8/31/09/07

Location	Loc Qty	Loc Code
FP-B	24	
114615	24	
ST356	46	
114615	46	

AN960JD416L NAS1149D0416J Purchased No 170 Each 19.0000 3 30
Washer



8/31/09/07

4 M116513
30x

Location	Loc Qty	Loc Code
FP-B	17	
110153	17	
ST298	2	
110153	2	

MS21042L4 Purchased No 170 Each 4,359.000 1 10
Nut



8/31/09/07

Location	Loc Qty	Loc Code
ST300	4359	
117441	214	
117601	645	
117885	1500	
118451	2000	

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

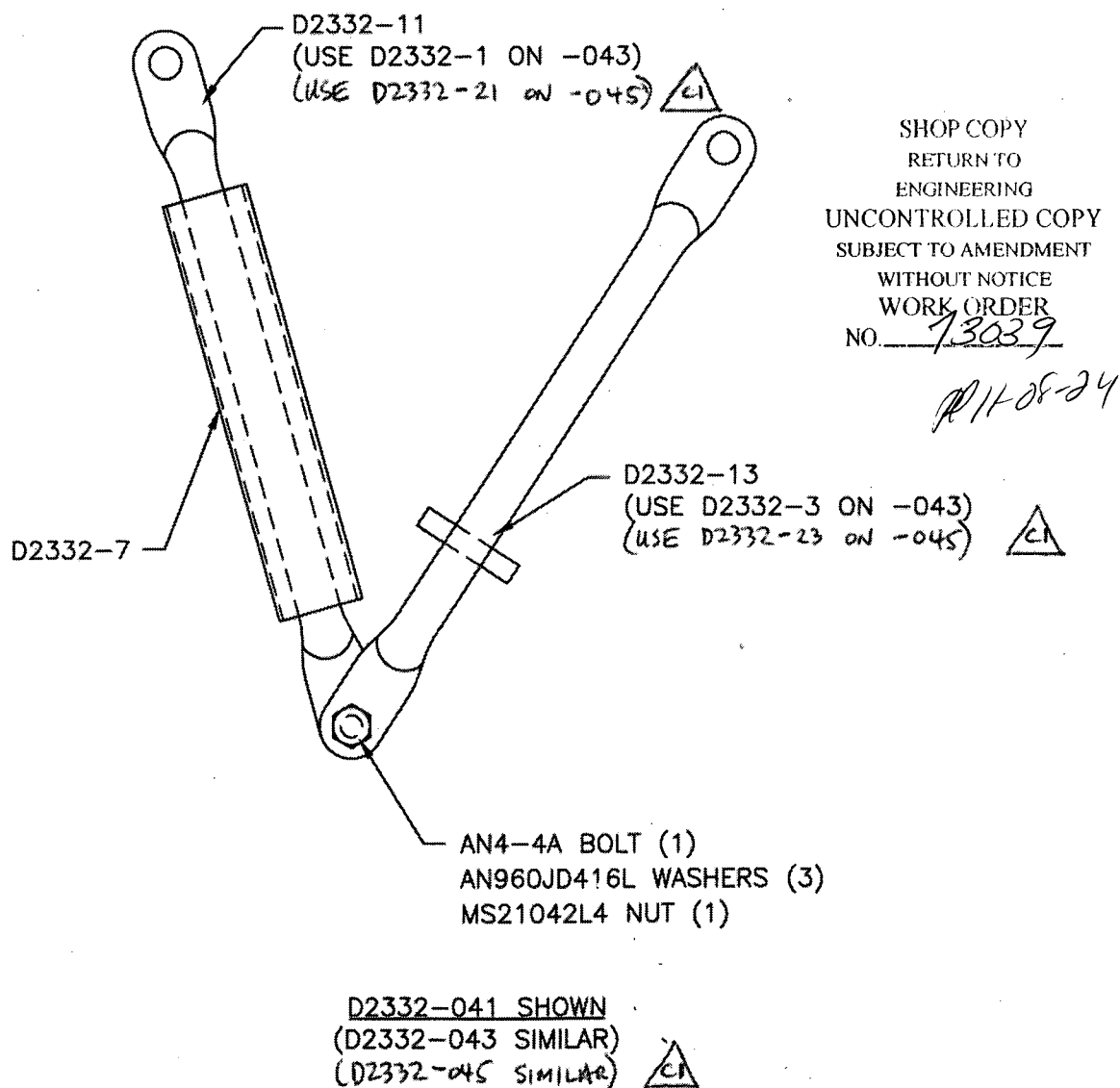
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[initials]*

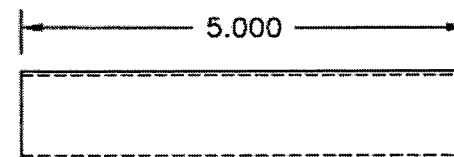


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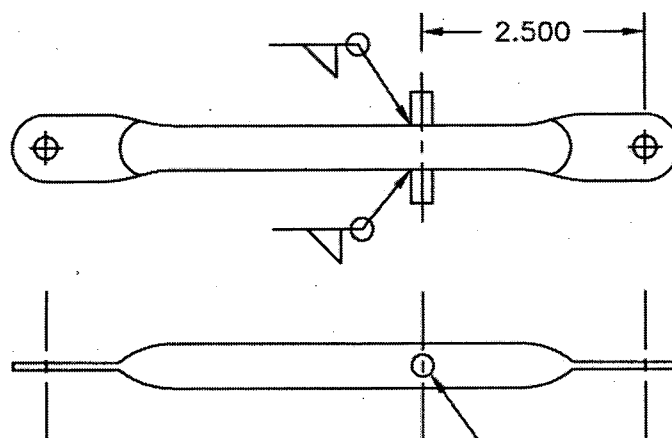
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ISSUED


DESIGN	<i>11</i>	DRAWN BY	<i>11</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>11</i>	APPROVED	<i>11</i>	DRAWING NO.	REV. C
DATE	03.07.03	TITLE	LID PROP ASSEMBLY	D2332	SHEET 2 OF 2
C	<i>11</i> 03.07.03	MAKE -041 PROP 6.64" LONG (57D) MAKE -043 PROP 8.00" LONG (07T)			
C1	<i>11</i> 03.08.06	ADD -045 PROP (725" LONG)			



D2332-11 PROP
(D2332-1 SIMILAR)



1.250



D2332-5 STOP PIN

DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

03-07-04

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